



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2274
Job Sheet 178962



Part No: D2274

Job Qty: 100 ea

DAS
21
9-89

Part Name: Radius Block



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/11/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP H 00.05.18 Added inspection level 8 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	100 Ea		6/29/18	0.00	0.00	Start Up Large Fab-7		DAS
100	Shear	100 pcs		6/29/18	0.00	0.05	Shear		54
110	CNC Vertical Machining	100 pcs		6/29/18	0.01	2.39	HAAS 1		9-89
130	QC	100 pcs		6/29/18	0.00	0.00	QC8		7/18/18/1/1
140	Small Fab	100 pcs		6/29/18	0.00	0.54	Small Fab		7/18/18/1/1
150	HandFinish	100 pcs		6/29/18	0.00	0.26	HandFinish1		7/18/18/1/1
160	QC	100 pcs		6/29/18	0.00	0.00	QC7		38
170	Packaging	100 pcs		6/29/18	0.00	0.00	Packaging3		JUL 20 2018
180	QC21-SA	100 Ea		6/29/18	0.00	0.00	QC21		21

Part Op 100 - blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

Descriptions: 110 - Machine as per folio D2274

140 - Tumble Deburr any rough edges after tumbling

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X00.125	6061-T6 Bar .750 X .125	8.3000 ft (.083 ea)	90-Start up Operation	5068502

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.750X00.125	8	87	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Radius Block	0.257inches + 0.005 - 0.000	0.262 0.257		
2	Radius Block	0.750inches ± 0.010	0.760 0.740		
3	Radius Block	0.375inches ± 0.010	0.385 0.365		
4	Radius Block	0.125inches ± 0.010	0.135 0.115		
5	Radius Block	0.750inches ± 0.010	0.760 0.740		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S089983 Part: D2274 Job No: 178962 Serial No/Batch: S089983 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/09/18			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
			Root Cause		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pr ☐ Be ☐ Ce ☐ Cr ☐ Cr ☐ Cl ☐ Cr ☐ He ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Instructions Incomplete/Unclear ☐ Drill Holes ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____

6

Radius Block

0.063inches $\pm$ 0.010

0.073

0.053

Plex 6/11/18 11:47 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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